

Work Order ID 127303

December-17-14 1:12:19 PM

127303

Page 1

Item ID: D5953 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 12/17/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5953	Rev B

100	HAAS CNC VERTICAL MACHINING #1	0.00				<u>4</u>	<u>0</u>		JFC 2015-03-18 DAS 37 15.03.19 9-99
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per folio D5953, Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble								
110	QC1- Inspect dimensions to dimension sheet	0.00				<u>4</u>	<u>0</u>		JFC 2015-03-18 DAS 37 15.03.19 9-99
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				<u>4</u>	<u>0</u>		DAS 08 9-99
120									
QC	Memo	0.00							
Quality Control									

D.A 15/03/21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127303

December-17-14 1:12:19 PM

127303

Page 2

Item ID: D5953 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 12/17/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4		15-3-23	<i>[Signature]</i>
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 120 808</i> Memo START TIME: <i>3:30</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>4:00</i>	0.00 0.00				11		15-3-28	<i>[Stamp]</i>
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(41)			DAS 38 9-89 MAR 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127303

December-17-14 1:12:20 PM

127303

Page 3

Item ID: D5953

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle

Stop

NS2

Start Date: 12/17/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>ST318</i>	0.00							
160									
Packaging	Memo	0.00				<i>48</i>	<i>68-6 92 SVD</i>		
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MAR 24 2015

*15/3/26**ME
15-3-24*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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Picklist Print

December-17-14 1:12:19 PM

Page 1

Work Order ID: 127303

127303

Parent Item: D5953

D5953

Parent Item Name: Saddle

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:f ecn 826 06.12.06 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	60.0000	1	4			

D6101-007

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT041	1	
121646	1	
MAT044	59	
114363	12	
116083	25	
119005	2	
120494	19	
76839	1	

→ 127646

4

JFC 2015-03-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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DART AEROSPACE LTD		Work Order:	127303
Description: Inner Fwd Saddle		Part Number:	D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

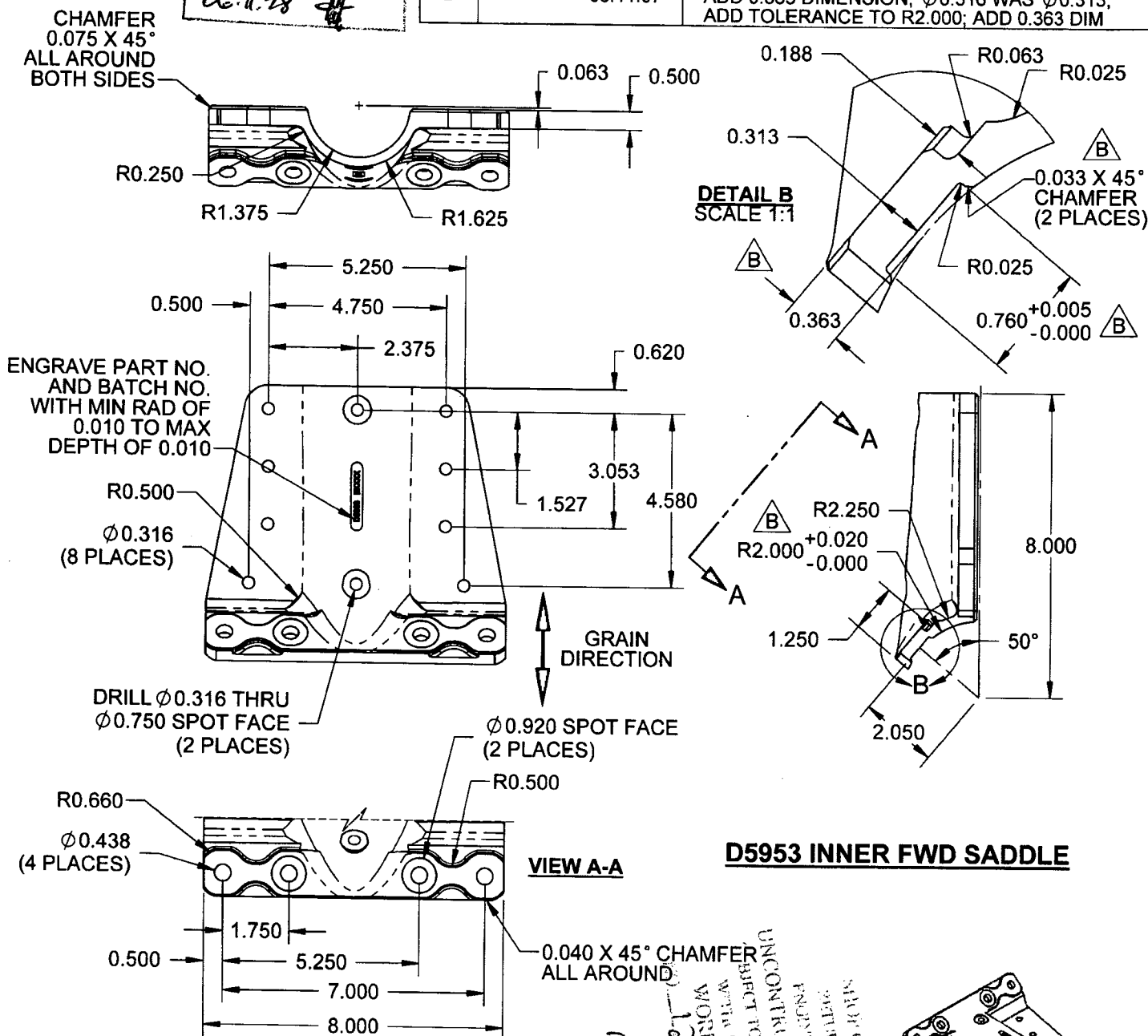
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.439	0.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.318	0.318	0.318	0.318		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.318	0.318	0.318	0.318		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.503	0.500	.501	.501		
N	1.615	1.635		1.627	1.631	1.630	1.629		
O	7.990	8.010		7.999	7.999	7.999	7.999		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.310	0.310	.311	.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.495	0.493	.496	.495		
T	1.375	1.395		1.3846	1.384	1.3849	1.384		
U	2.000	2.020		2.004	2.0034	2.0043	2.004		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: JFC	DAS
Date: 2015-03-18 / 15-03-19	Audited by: B.E.
	Date: 15/03/21

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	

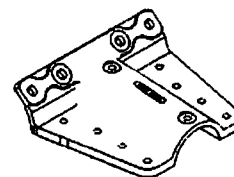


DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5953	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER FWD SADDLE SCALE 1:4		
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



ISOMETRIC VIEW
SCALE 1:8

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Part Number: D5953	Rev: B	- Page 1 -
Description: INNER FWD SADDLE	Inspection Dwg: D5953	Work Order: 127303

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
A Diameter	0.4380	0.0050 0.0000	0.4381	0.4382	0.4381	0.4380	
B Distance XY	1.7500	0.0050 -0.0050	1.7491	1.7500	1.7502	1.7497	
C Distance XY	5.2500	0.0050 -0.0050	5.2488	5.2497	5.2499	5.2497	
D Distance XY	7.0000	0.0050 -0.0050	6.9984	6.9987	6.9992	6.9989	
E Distance ZX	5.2500	0.0100 -0.0100	5.2484	5.2501	5.2483	5.2488	
F Distance ZX	4.7500	0.0050 -0.0050	4.7484	4.7488	4.7484	4.7488	
G Diameter	0.3160	0.0060 -0.0010	0.3157	0.3157	0.3155	0.3156	
H Distance XY	1.5270	0.0050 -0.0050	1.5275	1.5270	1.5273	1.5268	
I Distance XY	3.0530	0.0050 -0.0050	3.0543	3.0533	3.0536	3.0529	
J Distance YZ	4.5800	0.0050 -0.0050	4.5805	4.5799	4.5802	4.5802	
K Diameter	0.3160	0.0060 -0.0010	0.3156	0.3155	0.3156	0.3158	
L Distance ZX	0.5000	0.0050 -0.0050	0.5004	0.4988	0.5004	0.5001	
M Distance YZ	0.5000	0.0100 -0.0100	0.5047	0.5043	0.5046	0.5039	
O Distance XY	8.0000	0.0100 -0.0100	7.9978	7.9981	7.9981	7.9980	
S Distance XY	0.5000	0.0100 -0.0100	0.4952	0.4929	0.4963	0.4966	

Measured by:
Mathieu Lamarche

Date:
2015-3-19

Audited by: *D.A.* **DAS**
08
9-89

Date: 15/03/21